

Work Order ID 69932

Tuesday, May 24, 2011 2:24:34 PM



Page 1

Item ID:	D2857-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Hinge Bracket					
Start Date:	5/24/2011	Start Qty:	24.00		Cust Item ID:	
Required Date:	5/31/2011	Req'd Qty:	24.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-05-24	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D2857	Rev C	FAI REV B							

100		BAND SAW				0.00			
	Bandsaw	Memo				0.00			
	Jeaspa Bandsaw	Cut blanks 4.425"							

11/09/20

24 0

110		HAAS CNC VERTICAL MACHINING #1				0.00			
	HAAS 1	Memo				0.00			
	HAAS CNC vertical machine #1	1-Machine per folio #A940 FOLIO REV: DWG REV: 2-Deburr any rough edges							

FK/RE- 11.7.19

24 0

120		QC2- Inspect parts off machine FAI/FAIB				0.00			
	QC	Memo				0.00			
	Quality Control								

FK./SL 11/09/20

24 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69932

Tuesday, May 24, 2011 2:24:34 PM



Page 2

Item ID: D2857-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 5/24/2011 Start Qty: 24.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 24.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

B.A 11/09/21

24

0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

24 0 11/09/21

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:45
320 OF
2:15

24x0 M-11/09/21

M118439

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69932

Tuesday, May 24, 2011 2:24:34 PM



Item ID:	D2857-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Hinge Bracket					
Start Date:	5/24/2011	Start Qty:	24.00		Cust Item ID:	
Required Date:	5/31/2011	Req'd Qty:	24.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC3- Inspect Part Finish	0.00							
						24	0	11/09/22	
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: 24	0.00							
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/9/22 [Signature]
MF
11-09-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: ☒ _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 2:24:41 PM

Page 1

Work Order ID: 69932



Parent Item: D2857-1



Parent Item Name: Hinge Bracket

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP C00.06.22 Removed P/O for powder coat EC
IPP D06.05.01 Added level 8 EC IPP Rev:E
10.06.10 remove seq150 DD verf:JLM IPP Rev:F 11.01.06 as
per dwg revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B2.000X01.25

Purchased

No

100

f

6.3026

0.37

9.347368

0



FK/BP 11/09/20

6061-T6 Bar 2.00 x 1.25

Location

Loc Qty

Loc Code

MAT010

6.30263158

114899

4.15263158

116623

2.15

11800P x 17 Links
118641 x 7 blanks.

7.28 ~~5.11~~
2.596

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 69932
Description: Hinge Bracket		Part Number: D2857-1
Inspection Dwg: D2857 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.300				
4.000	+/-0.010	4.000				
0.340	+/-0.010	.338				
1.110	+/-0.005	1.112				
1.790	+/-0.010	1.790				
1.320	+/-0.005	1.320				
2.000	+/-0.010	2.000				
0.340	+/-0.010	.340				
0.447	+/-0.010	.449				
Ø0.171	+0.005/-0.000	.172				
0.147	+/-0.010	.147				
0.376	+/-0.010	.377				
0.126	+/-0.010	.127				
0.063	+/-0.010	.063				
Ø0.166	+0.005/-0.000	.166				
0.911	+/-0.010	.911				
0.600	+/-0.010	.597				
0.125	+/-0.010	.125				
0.150	+/-0.010	.150				

Measured by: F.K. / JL	Audited by: H.A	Prototype Approval:	N/A
Date: 11/09/20	Date: 11/09/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM	

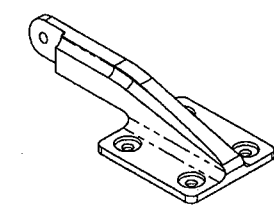
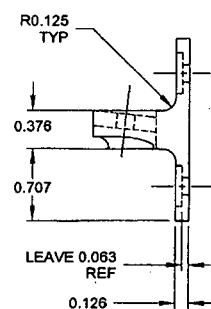
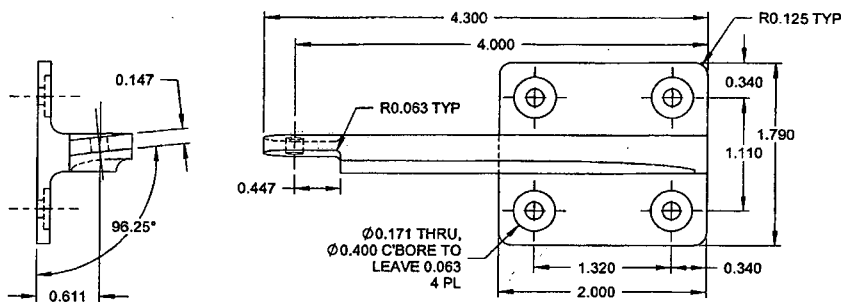
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

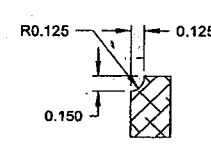
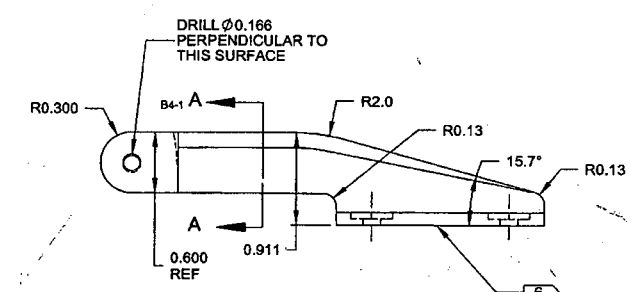
NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69932

11-05-24

RELEASED
2010-11-26



B7-1 SECTION A-A

D2857-1 HINGE BRACKET

- NOTES:**
- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: P/N "D2857-1" PER DART QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
 - 7) WEIGHT: 0.11 lbs

C	REFORMAT DWG. IDENTIFICATION BY MARKER WAS ENGRAVING (A8-1). REF PAR 10-040	CP	10.09.13
B	ADD THICKNESS, REDRAW W/ SOLIDWORKS	LE	06.08.28
A	NEW ISSUE	KE	98.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D2857	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	HINGE BRACKET	NTS
DATE	10.09.13	COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

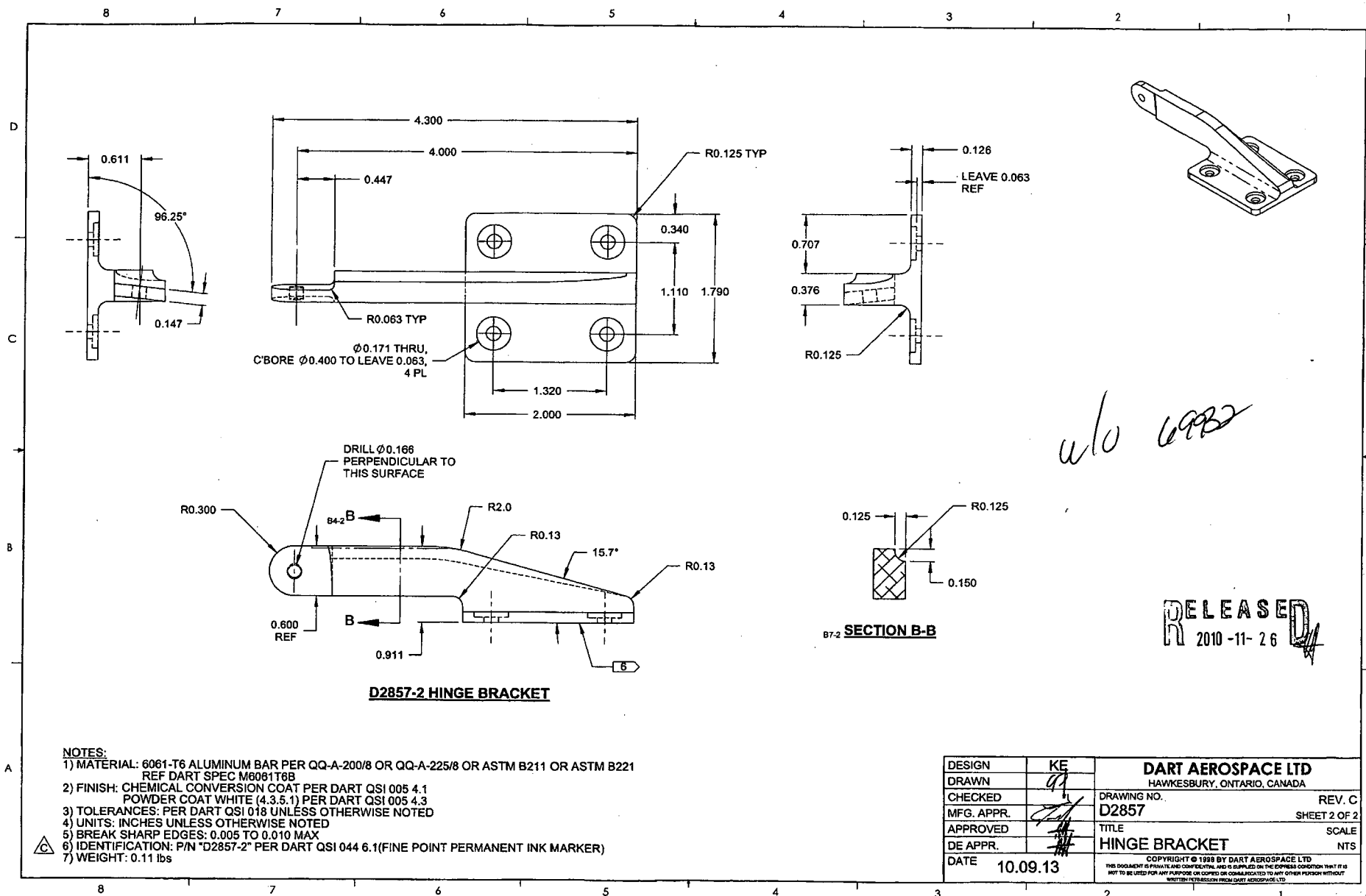
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries